

Date: Wednesday, 13/05/2009 11:28:12 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 407 STEP ASSEMBLY
Job Number	: 47932		
Estimate Number	: 11795		
P.O. Number	:	Part Number	: D206628033
This Issue	: 13/05/2009 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 46696	Material	:
Written By	:	Due Date	: 29/05/2009 Qty: 6 Um: Each
Checked & Approved By	: <u>Julie Dawson</u>		
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM Est Rev:E as per ecn 1118 08-02-05 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		<u>Scrubbed</u>
Comment: DOCUMENT CONTROL Photocopy blue file and type labels as per PPP D206-628-033 CHG 002 <u>CHG 083 per ecn 1118</u>		
2.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
3.0	47932A	FLOAT STEP ASSEMBLY LH (206/407)
		<u>Sub-Comp</u>
Comment: Sub-Component 206B STEP ASSY LH 1 x D2842-041 Batch <u>47932A 50</u>		
4.0	D2732	Rubber Extrusion
Comment: Qty.: 2.0000 f(s)/Unit Total : 12.0000 f(s) Qty Part # Description Batch 8 D2732 RUBBER CUSHION <u>B38509</u> <u>9/18/1</u> <u>50</u> CUT EIGHT PIECES 3.00" LONG		
5.0	D27313	Mounting Lug
Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s) Pick: Qty Part Number Description Batch 4 D2731-3 Mounting Lug <u>43313</u> <u>23</u> <u>1539441</u> <u>9/15/29</u> <u>50</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 47932

Part Number: D206628033

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

D28441

Arm



(102)

46844

50

9/6/11



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2844-1

Arm

47728

9/5/09

59

7.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2844-3

Arm

47729

4
46845
~~44684~~

9/5/09 SP

8.0

D3394041

Lug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D3394-041

LUG ASS,Y

46861

9/5/09
22
2X
42238

SP

9.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C4A

Bolt

4111668

9/6/11

SP

10.0

AN4C14A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 48.0000 Each(s)

Bolt

batch

4110105

9/6/11

SP

11.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

4111279

9/6/11

SP

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 47932

Part Number: D206628033

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total: 18.0000 EACH(s)

Pick:

Qty Part Number Description
3 AN960C10 WASHER

Batch

M109165

9/6/11

50

13.0

AN960C416L

WASHER



9/6/11



9/6/11

Comment: Qty.: 24.0000 Each(s)/Unit Total: 144.0000 Each(s)

Pick:

Qty Part Number Description
24 AN960C416L Washer

Batch

M111424

20

M111650

50

14.0

NAS1515H4L

WASHER



6

18

M101542

M102029



46

Comment: Qty.: 24.0000 Each(s)/Unit Total: 144.0000 Each(s)

Pick:

Qty Part Number Description
24 NAS1515H4L Washer

Batch

M10536

48

M105406

M111359

9/6/11

50

15.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 72.0000 Each(s)

Pick:

Qty Part Number Description
12 MS21043-4 Nut (or MS21042-4)

Batch

M111295

64

M111819

50

16.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description
3 NAS1515H3 Washer

Batch

M116397

8/5/29

50

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/09/06/02 (x644)

Date: Wednesday, 13/05/2009 11:28:12 AM
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Process Sheet

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Drawing Name: 407 STEP ASSEMBLY

Job Number: 47932

Part Number: D206628033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-033

Location: _____

PPP Rev: _____

0

09/06/02 (5)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



in 09.06.03

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. E

REF FAA STC: SA00500SE

REF CANADIAN STC: SH98-14

To help prevent the D206-628-XXX Heli-Access-Steps from sliding down the crosstubes during operation, D2732-030 Rubber Cushions have replaced the D2856-400-625/-690 Abrasion Strips in the kits shown in Table 1. The parts lists are amended as shown in Tables 2a and 2b or 3a and 3b. Install the D2732-030 Rubber Cushions as shown in Figure 1.

For customers who would like to upgrade their D206-628-011/-012/-013/-014/-021/-022/-023/-024/-031/-032/-033/-034 Heli-Access-Steps to have the D2732-030 Rubber Cushions, DSI 9332-011/-021 kits available as shown in Table 4. Remove the abrasion strips as described on Sheet 3 and install the DSI 9332-011/-021 kits as shown in Figure 1.

Table 1: D206-628-XXX Kits with D2732-030 Rubber Cushion

INSTALLATION	CHG NUMBER
D206-628-011/-012/-021/-022/-023/-024/-031/-032/-033/-034	003 OR LATER
D206-628-013/-014	004 OR LATER

Table 2a: Parts to Remove

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	PART NUMBER	DESCRIPTION
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1	1			2	2	D2856-400-625	ABRASION STRIP
1	1	2	2			D2856-400-690	ABRASION STRIP
4	4			4	4	AN4-11A	BOLT
4	4	4	4	4	4	AN4-12A	BOLT
		4	4			AN4-13A	BOLT

Table 2b: Parts to Add

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	PART NUMBER	DESCRIPTION
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
		4	4			AN4-15A	BOLT

REFERENCE ONLY - REFERENCE ONLY

WLO
47932

B	ADD DSI 9403-011/-021 KITS	PH	08.01.24
A	NEW ISSUE	MB	06.05.10
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9332	SHEET 1 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	RUBBER CUSHION ADDITION	NTS
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Table 3a: Parts to Remove

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	PART NUMBER	DESCRIPTION
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
1	1			2	2	D2856-400-625	ABRASION STRIP
1	1	2	2			D2856-400-690	ABRASION STRIP
4	4					AN4C11A	BOLT
4	4	4	4	8	8	AN4C12A	BOLT
		4	4			AN4C13A	BOLT

Table 3b: Parts to Add

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	PART NUMBER	DESCRIPTION
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
		4	4			AN4C15A	BOLT

47932

DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9332	SHEET 2 OF 4
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DE APPR.	PH	RUBBER CUSHION ADDITION	NTS
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Table 4: Upgrade Kits

QTY -011	QTY -021	PART NUMBER	DESCRIPTION
X		DSI 9332-011	RUBBER CUSHION KIT (D206-628-011/-012 206 A/B STEPS) (D206-628-021/-022 206L STEPS) (D206-628-031/-032 407 STEPS)
	X	DSI 9332-021	RUBBER CUSHION KIT (D206-628-013/-014 206 A/B FLOAT STEPS) (D206-628-023/-024 206L FLOAT STEPS) (D206-628-033/-034 407 FLOAT STEPS)
8	8	D2732-030	RUBBER CUSHION
4		AN4-13A	BOLT
4		AN4-14A	BOLT
4		AN4-15A	BOLT
16		AN960JD416	WASHER
8		MS21042L4	NUT (OR MS21042-4)
	4	AN4C13A	BOLT
	8	AN4C14A	BOLT
	4	AN4C15A	BOLT
	16	AN960C416	WASHER
	16	NAS1515H4L	WASHER
	8	MS21043-4	NUT

Note: Some AN4 bolts will not be used for all installations

ABRASION STRIP REMOVAL

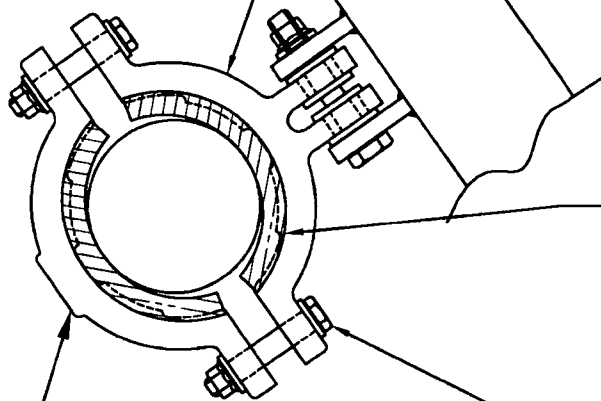
1. Being careful not to mark/scratch the part on which it is installed, lift edge and carefully peel Abrasion Strip at an angle of 90 to 180 degrees. Speed and angle of removal may affect amount of residue and the amount of paint removed.
2. Remove adhesive with 3M 8908 Woodgrain and Stripe Remover (or equivalent). Scrape softened adhesive off the surface using plastic squeegee after the remover has sat for the required amount of time. Repeat if required.
3. Remove remaining adhesive by scrubbing area with a cloth and 3M 8908 Woodgrain and Stripe Remover (or equivalent). Scotchbrite may be used as required.
4. Saturate a clean cotton cloth with Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser followed by alcohol, or equivalent and wipe the surface to clean the entire area.

47932

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DRAWN	PH	PORT HADLOCK, WA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9332	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RUBBER CUSHION ADDITION	NTS
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D3394-041 LUG (1) OR
D3394-043 LUG (1)
(4 PLACES - REFER
TO TABLE 5)

*ACCEPTABLE TO USE LONGER/SHORTER
AN4 BOLTS AS REQUIRED AND/OR INSTALL
EXTRA AN960JD416 WASHERS UNDER THE BOLT HEADS
TO ENSURE 1.5 TO 4 THREADS IN SAFETY



D2732-030 RUBBER CUSHION
(8 PLACES)

D2731-3 LUG (1) OR
D2731-7 LUG (1)
(4 PLACES - REFER TO TABLE 5)

INSTALL LONGER AN4 BOLTS PER TABLE 5
AND FIGURE 2 OR 4 OF IIN-D206-628 REV E
AS APPLICABLE

FIGURE 1: DSI 9332-011 RUBBER CUSHION INSTALLATION (REGULAR STEPS)
(DSI 9332-021 KIT (FLOAT STEPS), SIMILAR)

Table 5: Bolts/Lugs for Installation

Aircraft	Location	Lugs	Bolts to Use for Regular Steps	Bolts to Use for Float Compatible Steps
206 B Series	Aft X-tube	D3394-041/ D2731-3	AN4-13A	AN4C13A
	Fwd X-tube	D3394-043/ D2731-7	AN4-14A	AN4C14A
206 L Series	Aft X-tube	D3394-043/ D2731-7	AN4-15A	AN4C15A
	Fwd X-tube	D3394-043/ D2731-7	AN4-14A	AN4C14A
407 Series	Aft X-tube	D3394-041/ D2731-3	AN4-13A	AN4C14A
	Fwd X-tube	D3394-041/ D2731-3	AN4-14A	AN4C14A

47932

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CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9332	SHEET 4 OF 4
APPROVED	PH	TITLE	SCALE
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